

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026229**Date Inspected:** 06-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Pat Swain**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

East Line

This QA randomly observed ABF/JV qualified welder Fred Kaddu #2188 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E4-PP76-L#2, 4 and was performed in the overhead position from the inside of the "A" deck plate.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=137).

This QA randomly observed ABF/JV qualified welder Jorge Lopez #6149 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E4-PP104-L#2, 4 and was performed in the overhead position from the inside of the "A" deck plate.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters.

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Welding parameters were recorded as (A=136).

Approximately-

8:05- this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the completed welds at this panel point E4-PP103-L#1, 3 location. Mr. Vonhoff recorded no rejectable indications at this time.

11E/12E

This QA randomly observed ABF/JV qualified welder Wai Kit Li #2953 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1001-R. . The joint being welded was in the 1G flat position at the bottom plate D2 on the inside of the OBG 11E/12E.

Measurements are recorded in millimeters.

D2

Indication (Y=460), Excavation (Y=500, L=85, W=17, D=15)

Indication (Y=2975), Excavation (Y=2945, L=80, W=15, D=10)

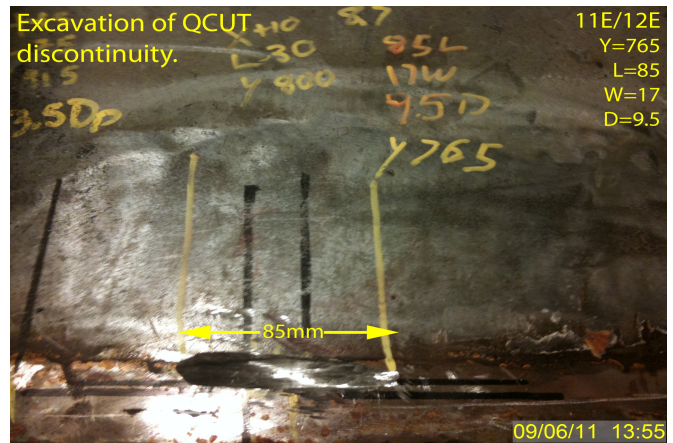
Indication (Y=3150), Excavation (Y=3125, L=65, W=12, D=7)

Indication (Y=3310), Excavation (Y=3270, L=90, W=20, D=18)

Indication (Y=3380), Excavation (Y=3360, L=120, W=23, D=15)

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as (A=135).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer